

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.15**SOURCE INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** SIR-000652**Date Inspected:** 16-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 0**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 12**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Changxing Dao, Shanghai

Quality Control Contact:	ABF Paint Supervisor William (Bill) Oak			Quality Control Present:	Yes	No
Material transfer:	Yes	No	N/A	Sampled Items:	Yes	No N/A
Stock Transfer:	Yes	No	N/A	OK to Cut:	Yes	No N/A
Rebar Test Witness:	Yes	No	N/A	Delayed/Cancelled:	Yes	No N/A

Other: Surface Preparation and Coatings Application**Bridge No:** 34-0006**Component:** OBG 1AE, Lift 3&4, Misc. Metal, Tower L1E**Bid Item:** 77,78,79,80**Lot No:** B226**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials (OSM) Quality Assurance (QA) NACE III coating inspector, Mr. Donald Jordan arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island in Shanghai, China. The purpose of the coating inspections are to monitor the surface preparation and coating applications for the SAS Bay Bridge project. This QA NACE III coating inspector observed the following: The following inspections were performed by Caltrans QA Coatings Inspector Jordan, American Bridge/Fluor Enterprises, a JV (ABF) Paint Supervisor William (Bill) Oak, ABF QC Zhou Qun Song (Joe), ABF QC David Duon, ABF QC Shi Zhaoyuan (Stone), ABF QC Zhou Wei, International Paint (IP) Onsite Technical Services Engineer (OTSE) Peng Zi Li, IP OTSE Alpha Chen, Zhenhua Port Machinery Company, LTD (ZPMC) QC Manager Xia Yong, ZPMC QC Zhang Diang, ZPMC QC Dong Yao Fei and ZPMC QC Guo Wan Li. Caltrans QA Coatings Inspectors received Notices of Inspection for to attend joint inspections with ABF and ZPMC QC for surface preparation by abrasive blasting.

OBG Trial Assembly Area

An inspection notice was received to look at the weld area in lifts 3 and 4 that had been abrasive blasted. ABF Paint Supervisor William (Bill) Oak instructed ZPMC to perform all the blast repairs in the area instead of just the weld seam. Several other spots of damage were adjacent to or joining the blasted area. The inspection was canceled until after more blasting is performed to square up the area.

Tower

Around 21:00 hours last night ABF Paint Supervisor Don Walton called requesting inspection prior to primer application on the external surfaces of Tower L1 E. There were no Caltrans Coatings Inspectors on site due to

SOURCE INSPECTION REPORT

(Continued Page 2 of 3)

scheduling. Caltrans Coatings/Welding Inspector Mark Miller has looked at the first blast of the exterior surfaces prior to grinding repairs and VT inspection. Mr. Miller reported that the blast looked good prior to grinding with few areas marked up for re-blast. When Mr. Jordan arrived on site at 00:00 05/16/2009 primer application to the external surfaces of the tower section L1 E was complete.

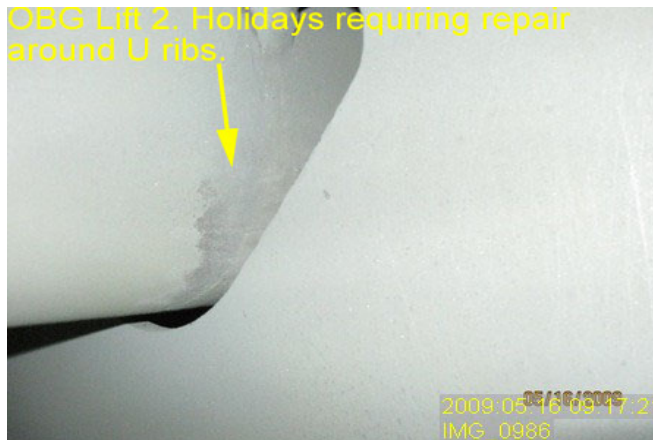
Miscellaneous Metal

The following OBG components were abrasive blasted and inspected: channels 12 pcs, crane rail support 12 pcs, cable support 5 pcs, manhole cover 28 pcs, shim plates 68 pcs, splice plates 650 pcs and angle bar 388 pcs. A few spots of grinding were required to remove arc strikes, sharp edges, dings in the substrate that left sharp edges sticking up, and edge conditioning required by the Project Special Provisions Section 10-1.69. After the grinding was completed the surfaces were re-blasted to meet the SSPC SP10 Contract requirements. Surface profile Testex Tape was used by ZPMC QC personnel to record the blast profile. The Testex tape was measured using a dial micrometer. The readings were within the contract requirements of 40 and 86 microns. Ambient conditions were within Contract required parameters. After the base metal was prepared to meet the contract requirements, Interzinc 22 primer was applied within the specified 8 hour window after the start of abrasive blasting. The coating was mixed under the supervision of Caltrans QA Coatings Inspector Jordan, International Paint's Onsite Technical Services Engineer Peng Zi Li and QC personnel representing ABF and ZPMC.

OBG 1AE

Caltrans QA Coatings Inspectors received a Notice of Inspection for to attend a joint inspection with ABF and ZPMC QC to locate visual surface anomalies and weld defects on the floor area of OBG 2AW. ABF verbally requested that the Caltrans welding staff be notified to perform VT inspection after blast. Areas requiring grinding were identified and marked by QC and QA staff. Caltrans QA Weld Inspector's performed VT inspection to locate and mark any weld repairs required. The weld repair spots were identified by placing tape over the area so it can be located after primer application. After the inspection was complete, grinding was performed to remove base metal defects. Abrasive blasting resumed after grinding was completed. NO ZPMC or ABF steel inspectors were on site looking at the welds.

Fabrication on assembled components of the OBG's are not complete. Coating damage requiring re-blast is expected.



SOURCE INSPECTION REPORT

(Continued Page 3 of 3)

Summary of Conversations:

There were no relevant conversations on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh (China) +8613472477571, who represents the Office of Structural Materials for your project.

Inspected By:	Jordan,Don	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
